Work Order ID 87204 *87204*

July-11-12 10:10:37 AM

Item ID: D350-604-041 **Accept** *N900040100* **Setup** **Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Rear Locker Extender

Start Date: 7/16/12 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 8/24/12 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run **Start** *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2273	F
D350-604-041	B

SCRAP

100 *100* DC Document Control — DOCUMENT CONTROL — 0.00 / 0.00

Memo

Photocopy bluefile and create labels per PPP D350-604-041

CHG003 for D2273 rev.E (new gelcoat)

CHG004 for D2273 rev.F (new primer)

scrap

110 *110* Purchasing Purchasing — PURCHASING — 0.00 / 0.00 — u 12-07-31

Memo

Issue P/O: 17579

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 122317

4 x 2600-LW Retaining washers - Ship to Delastek B 121627

pl 12-07-31

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** __________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Item ID: D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Rear Locker Extender

Start Date: 7/16/12 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 8/24/12 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Packaging	0.00				1ч			SP 12-8-16.
	Memo Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.	0.00							
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo Check hole locations to template. DT 8824 Check process sheet and audit.	0.00 DAS 15 17/6/17							PTO →
140 *140* Small Fab Small Fab		0.00							
	Memo INSTALL DECALS AS PER DWG	0.00							

Dart Aerospace Ltd

W/O: 87204		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		See pink NCR 12-1819					

Part No: D350-604-041 **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes No **DQA:** [signature] **Date:** 12/09/18

Resolution: ______ **Disposition:** SCRAP. **QA: N/C Closed:** ______ **Date:** ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
12/08/17	# 100	Parts are not Primed on the outside R.C. Supplier Fails to follow instruction	DAS 16 9-89 QS2042 12/08/17	Prime as Per Dwg + Per QS2004	[signature] 12.09.17		DAS 16 9-89 QS2042 12/08/17	DAS 16 9-89 12/08/17
		Found that the Parts are too heavy. it weights 14.0lbs should be 7.75lbs. and has large chipp on						DAS 16 9-89 12/08/17
		the corner. R.C. ~~supplier~~, manuply made.						DAS 16 9-89 12/08/17

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 87204

87204

July-11-12 10:10:37 AM

Item ID: D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Rear Locker Extender

Start Date: 7/16/12 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 8/24/12 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** __________ **Date:** ________

QC: ________________ **Date:** ________ **SPC (Y/N):** __________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				____	____	____	____
160 *160* Packaging Packaging	Packaging **Memo** Identify and pack for shipping as per PPP D350-604-041 Location:__________ PPP Rev:__________	0.00 0.00				____	____	____	____
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00				____	____	____	____

CZ 12/09/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

July-11-12 10:10:37 AM

Work Order ID: 87204
Parent Item: D350-604-041
Parent Item Name: Rear Locker Extender
Start Date: 7/16/12
Start Qty: 1.00
Required Date: 8/24/12
Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R 12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 Camlock Stud		Purchased	No			110	Each	199.0000	**4**	**4**			
2600-LW Camloc Retaining Washer		Purchased	No			110	Each	319.0000	**4**	**4**			
D2268 Decal		Manufactured	No			140	Each	31.0000	**1**	**1**			

2600-6 locations:

Location		Loc Qty	Loc Code
ST380		199	
	120077	8	
	121556	4	
	122317	42	
	122335	145	

2600-LW locations:

Location		Loc Qty	Loc Code
ST380		316	
	121524	116	
	122317	200	
ST381		1	
	121287	1	
ST398		2	
	120648	2	

D2268 locations:

Location		Loc Qty	Loc Code
ST007		20	
	80010	20	
ST009		11	
	69592	2	
	78908	9	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: ____________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: _________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 87204
Parent Item: D350-604-041
Parent Item Name: Rear Locker Extender

Start Date: 7/16/12 **Required Date:** 8/24/12
Start Qty: 1.00 **Required Qty:** 1.00

D2269 Decal	Manufactured	No		Each	25.0000		1
		Location	**Loc Qty**	**Loc Code**			
		ST007	20				
		80011	20				
		ST009	5				
		78920	5				
D350-604-041P Rear Locker Extender	Purchased	No	110	Each	0.0000	1	1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

****Certificate of Conformity****

Customer:
Dart Aerospace

Purchase Order #:	Packing Slip #:	Part #:	Serial #:
PO17579		D350-604-041P	N/A

Description:	Quantity:
Stealth spec 2 ply flange locker	1

Certification:

We hereby certify that:

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;

2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;

3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

APPROVAL:	DATE:
Signature: [signature]	8/15/2012
Title: President	

Stealth Composites Inc.

Process Data Sheet

Date:	8/13/12	Part Name:	Stealth spec extended locker
Client:	DART	Part Number:	D350-604-041P
Job:		Revision:	n/a
Comments:	Stealth spec locker 2 ply flange	Material:	fiberglass/FR polyester resin
		Quantity	1

Resin:	Hetron FR 650 T-20	Batch:0001291211
Gelcoat:	G730AA1100	Batch: G31
Catalyst	Cadox M-50A	Batch:12041F0701
Fiber:	1.5 oz random fiberglass mat	

	Operation	Date	Initial
Setup:	n/a		
Mold Prep:	clean with dry cloth	8/13/12	jad
Material prep:	Cut fiberglass to fit mold	8/13/12	jad
Mix gelcoat:	Catalyze gelcoat @1.5% Cadox	8/13/12	jad
Apply gelcoat:	Spray mixed gelcoat onto mold	8/13/12	jad
Mix resin:	Catalyze resin @1.5% Cadox	8/13/12	jad
Apply Fibers:	apply cut fiberglass mat to mold	8/13/12	jad
Apply Resin:	Saturate fibers with resin	8/13/12	jad
Cure time:	24 hrs		
Demold:	remove locker from mold	8/14/12	jad
Trim:	cut and sand flange per drawing	8/15/12	jad
Drill holes:	4 holes drilled per drawing	8/15/12	jad

Stealth Composites
COMPANY NAME
3N Columbus Blvd
COMPANY ADDRESS

COMMERCIAL INVOICE

INTERNATIONAL AIR WAYBILL NO. 8654 7028 2311

(NOTE: All shipments must be accompanied by a Federal Express International Air Waybill.)

DATE OF EXPORTATION
8-15-12

EXPORT REFERENCES (i.e., order no., invoice no.)

SHIPPER/EXPORTER (complete name and address)
Stealth Composites
3N Columbus Blvd
Philadelphia PA 19106

CONSIGNEE (complete name and address)
Dart Aerospace
1270 Aberdeen St
Hawkesbury ON K6A1K7

COUNTRY OF EXPORT
USA

COUNTRY OF MANUFACTURE
USA

COUNTRY OF ULTIMATE DESTINATION
Canada

IMPORTER — IF OTHER THAN CONSIGNEE (complete name and address)

MARKS/NOS.	NO. OF PKGS.	TYPE OF PACKAGING	FULL DESCRIPTION OF GOODS	QTY.	UNIT OF MEASURE	WEIGHT	UNIT VALUE	TOTA VALU
	3	box	Fiberglass Bin	1	Box		800	[illegible]

TOTAL NO. OF PKGS.: 3

TOTAL WEIGHT: 20

TOTA INVOI VALU

SEE REVERSE SIDE FOR HELP WITH THE ABOVE SECTION

Check c
☐ F.O.
☐ C &
☐ C.I.F

FOR U.S. EXPORT ONLY: THESE COMMODITIES, TECHNOLOGY, OR SOFTWARE WERE EXPORTED FROM THE UNITED STATES IN ACCORDANCE WITH THE EXPORT ADMINISTRATION REGULATIONS. DIVERSION CONTRARY TO UNITED STATES LAW IS PROHIBITED.

I DECLARE ALL THE INFORMATION CONTAINED IN THIS INVOICE TO BE TRUE AND CORRECT.

SIGNATURE OF SHIPPER/EXPORTER (Type name and title and sign.) [illegible]

DATE [illegible]

DART Aerospace
1270 Aberdeen ST

Nº DE COMMANDE - ORDER NO. PO 17579	DÉP. - DEPT.	DATE 31/07/2012

VENDU À - SOLD TO	EXPÉDIÉ À - SHIP TO Stealth Composite
ADRESSE - ADDRESS	ADRESSE - ADDRESS Philadelphia PA 19106

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	Nº D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON

20 x	2600-6 Cam lock B 122317	
20 x	2600-LW Retaining washers B 121524	
	for rear locker D 350-604-041	
	Thank You	
	[signature]	

Ref: P017579
Dep:
Date: 31Jul12
Wgt: 0.50 LBS
CV: 0.00
of Pkgs: 1
SHIPPING: 43.06
SPECIAL: 6.03
HANDLING: 0.00
TOTAL: 49.09
Svcs: INTL PRIORITY ISR
TRCK: 9018 2264 0236

TPS/GST

TVP/PST

230924

SIGNATURE	Nº LIC. - LIC. NO.	TOTAL

Blueline DCB156

FORMULAIRE DE VENTE – SALES ORDER

ACI-901822640236

Commercial Invoice

Invoice Number	Purpose of Shipment	Curr	Ult Dest.	Air Waybill Nbr.
	Gift	USD	US	901822640236
Export Dt	C.I. References	Pkgs	Bill T/C	Bill D/T/F
7/31/2012	PO17579	1 BOX	1517-9324-0	1517-9324-0

Shipper:
Ruth Molnar
Dart Aerospace Ltd.
1270 Aberdeen St.

HAWKESBURY
ON K6A1K7 CA (613) 632-5200
ID/EIN:

Consignee:
John Dice
Stealth Composites Inc.
3 North Columbus Blvd.

PHILADELPHIA
PA 19106 US (215) 919-7584
ID/EIN:

Broker

Importer
John Dice
Stealth Composites Inc.
3 North Columbus Blvd.

PHILADELPHIA
PA 19106 US (215) 919-7584
ID/EIN:

Part Nbr:D2600-6 Marks/Nbrs: Cntry MFG:CA Net Wgt: 0.00 lbs
HS Code: 8803.30. Unit Qty: 20.00 PCS Unit Value: 3.000000 Commodity Value: 60.00

Desc: Camlock stud

Total Shipment Weight: 0.5

Total Commodity Value: 6
Terms of Sale: FC
Freight:
Insurance:
Others:
Total Invoice Value: 6

Comments:
1)
2)
3)

I declare all information in this invoice to be true and correct.
Signature of shipper: Ruth Molnar 7/31/2012

DART aerospace

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17579

Purchase Order Date 7/31/2012
PO Print Date 8/1/2012

Order From : VU-STE002

STEALTH COMPOSITIES INC.
3 NORTH COLUMBUS BLVD.
PHILADELPHIA, PHILADELPHIA PA 19106
USA

Contact Name		**Buyer**	Linda Lacelle
Vendor Phone	215-919-7584	**Requisition Nbr**	
Vendor Fax	215-689-4979	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr		**Terms**	Net 10
		Currency	USD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D350-604-041P	Rear Locker Extender	8/15/2012 Yes	1.00 Each	FedEx PI collect	$475.0000	$475.0(
		Special Inst:	PRICING TO BE DISCUSSED BETWEEN JOHN FROM STEALTH AND ISAM FROM DART MADE WITH RADOM MAT				
2	D350-604-041P	Rear Locker Extender	8/15/2012 Yes	1.00 Each	FedEx PI collect	$475.0000	$475.0(
3	D350-604-041P	Rear Locker Extender	8/15/2012 Yes	1.00 Each	FedEx PI collect	$475.0000	$475.0(
4	D350-604-041P	Rear Locker Extender	8/15/2012 Yes	1.00 Each	FedEx PI collect	$475.0000	$475.0(

SP 12-8-16.

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required - YES NO

Change Nbr: 2 **Change Date:** 8/1/2012